

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004599**Date Inspected:** 10-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:****Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:****Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:****Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:****Yes No N/A****Delayed / Cancelled:****Yes No N/A****Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Tower Skin Plate	NA	NA	QA-UT

Tower

Heavy Shop 1: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001385. The subassembly is identified as Lift 2 tower skin plate "B" longitudinal stiffener, splice plate weld SSD1-SA163A/D-5A. QA inspector observed that the welds have been UT inspected and identified as accepted by ZPMC QC, Mr. Sun Yin. Caltrans QA-UT coverage was approximately 10%. The weld was found to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, November 10, 2008 for additional information.

Also, ZPMC notification of witness inspection, document number 001386 was presented to Caltrans QA for ultrasonic test inspection, welds SSD1-SA109-1A/B, SSD1-SA109-2A/B and SSD1-SA109-3A/B. Caltrans QA observed that ZPMC have not completed their ultrasonic test inspection of the welds.

2	Tower Skin Plate	NA	NA	QA-UT
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Tower

Heavy Shop 2: Caltrans QA inspector performed ultrasonic test (UT) inspection per ZPMC notification of witness inspection, document number 001385. The subassembly is identified as Lift 1 tower skin plate "A" splice plate weld, WSD1-SA1017A/J-17A. QA inspector observed that the welds have been UT inspected and identified as accepted by

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ZPMC QC, Mr. Xu Ronggang. Caltrans QA-UT coverage was approximately 10%. The weld was found to be in conformance with the project specifications. See Caltrans Ultrasonic Test Report (TL-6027) dated, November 10, 2008 for additional information.

The following digital picture illustrates inspected weld.

Also, ZPMC notification of witness inspection, document number 001388 was presented to Caltrans QA for ultrasonic test inspection, weld ESD1-SA388A/D-3a/b. Caltrans QA observed that the weld had been inspected by ZPMC and rejected.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 137-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
